



SOBRACORE®
TECHNOLOGIES FOR BRAZING

**Manufacturer of
technical & tailored
products for brazing**



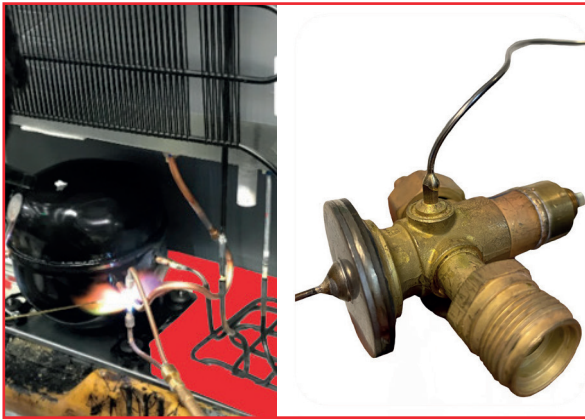
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ISO 9001:2015



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INTRODUCTION

The brazing market is a rapidly evolving market in all industrial sectors such as the HVAC sectors, Automobiles, Constructions, carbide tools, energy production.



With the evolution of constraints: Applications, HSE, Cadences, Costs, the need to adapt products is permanent with a limited market offer. This is the reason why we specialize in the development and manufacture of zinc-based, aluminium and silver-filled brazing, the **SOBRACORE** company provides industrialists with the expertise of its members in the search for solutions for the development of improvement of the brazing process by studying and finding global solutions.

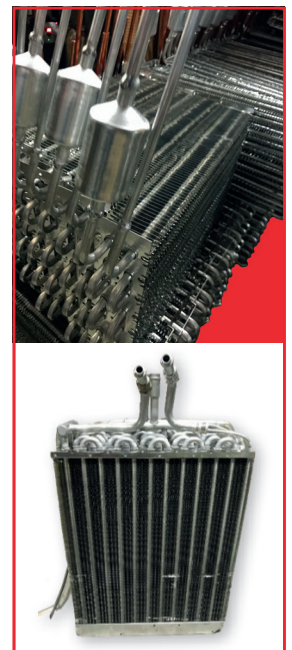
Research, development and innovation are the heart of our strategy.



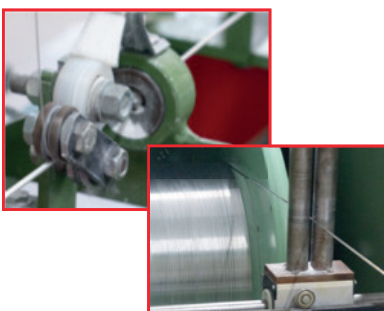
SOBRACORE OFFERS

- Consulting analysis on customer processes
- Study according to product specifications
- Study for turnkey global brazing solutions
- Adjustment of products according to assembly configuration
- Follow-up of tests
- Supply of products

Since 2019, **member of the French Welding Institute** with which we have partnership agreements for technical and scientific studies of brazing products and their applications.



MEANS OF PRODUCTION



We design and develop our own production machines and adapt the control means from commercial systems with a permanent watch of technological evolutions.

The **SOBRACORE** company constantly adapts its means of production according to the requirements of the markets.

PRODUCTS, RANGES & APPLICATIONS

Flux cored wire Aluminium & Zinc Aluminium:

Product	Alloy composition %				Melting range		Standard	
	Al	Si	Zn	Others	Solidus	Liquidus	AWS A5.8	ISO 17672
FCW SOBAL 1	Specific alloy				420		-	-
FCW SOBAL 2	2	-	98	-	382	407	-	-
FCW SOBAL 12	88	12	-	-	575	585	B ALSI-4	AL 112
FCW SOBAL 15	15	-	85	-	382	450	-	-
FCW SOBAL 22	22	-	78	-	420	480	-	-
SOBAL EXPRESS	Specific alloy				390	405		

PRODUCTS:

- **FCW SOBAL 1:** Aluminium-free zinc cored wire specially designed for specific applications that must resist certain types of corrosion (aluminium / aluminium or aluminium / steel / copper / brass / stainless steel)
- **FCW SOBAL 2:** 2% zinc-aluminium cored wire for universal aluminium / aluminium or aluminium / steel / copper / brass / stainless steel applications
- **FCW SOBAL 12:** Aluminium cored wire 12% silicon with a non-corrosive flux which is available in different diameters with or without internal solid wires for the adjustment of the metal / flux ratio as well as a wide range of fluxes to meet all applications
- **FCW SOBAL 15:** 15% zinc-aluminium cored wire for application combining low melting points with high mechanical performance. Specially developed for ring application
- **FCW SOBAL 22:** 22% zinc-aluminium cored wire for application combining low melting points with high mechanical performance
- **SOBAL EXPRESS:** Universal alloy designed for maintenance and repair for aluminum alloys in homogeneous or heterogeneous with steel, copper, brass and stainless steel. Its packaging is suitable for installers, maintenance services and also for industrial applications



Silver Flux Cored Wires:

Product	Melting range		Nominal composition %					Standards	
	Solidus	Liquidus	Ag	Cu	Zn	Sn	Other(s)	AWS A5.8	ISO 17672
FCW SOBAG 20	690	780	20	45	34	1	-	-	-
FCW SOBAG 25	680	760	25	40	33	2,0	-	BAG-37	AG 125
FCW SOBAG 25T	700	790	25	40	35	-	-	-	AG 225
FCW SOBAG 30	665	755	30	36	32	2	-	-	AG 130
FCW SOBAG 30T	680	765	30	38	32	-	-	BAG-20	AG 230
FCW SOBAG 34	630	730	34	36	27,5	2,5	-	-	AG 134
FCW SOBAG 38	650	720	38	32	28	2,0	-	BAG-34	AG 138
FCW SOBAG 40	650	710	40	30	28	2,0	-	BAG-28	AG 140
FCW SOBAG 45	640	680	45	27	25,5	2,5	-	BAG-36	AG 145
FCW SOBAG 45T	665	745	45	30	25	-	-	BAG-5	AG 245
FCW SOBAG 49	680	705	49	16	23	Mn 7,5	Ni 4,5	BAG-22	AG 449
FCW SOBAG 49S	679	690	49	27,5	20,5	Ni 0,5-Mg 2,5	0,15 Max	-	-
FCW SOBAG 50N	660	705	50	20	28	-	Ni 2,0	BAG-24	AG 450
FCW SOBAG 56	620	655	56	22	17	5,0	-	BAG-7	AG 156

All the shades offered are also available as solid wires.

The FCW SOBAG range is developed with **carefully selected raw materials** and benefits from an integrated flow corresponding to the main application for which the alloy is intended. It is quite possible to adjust the type of feed in relation to the application.

Flux for Aluminum & Zinc Aluminum applications:

Product	Temperature range (°C)		Brazing alloys	Corrosive	Non corrosive	Standard	Powder	Paste
SOBAL-FLUX C	540	650	AlSi	✓		FL10	✓	✓
SOBAL-FLUX C 1	520	640	AlSi	✓		FL10	✓	✓
SOBAL-FLUX C 1 HD	520	640	AlSi	✓		FL10		✓
SOBAL-FLUX C 1 HDS	520	640	AlSi	✓		FL10		✓
SOBAL-FLUX N	565	572	AlSi		✓	FL20	✓	✓
SOBAL-FLUX CS	420	450	ZnAl		✓	FL20	✓	✓
SOBAL-FLUX NC	430	570	AlSi/ZnAl		✓	FL20	✓	✓

Flux for Silver Bases applications:

Product	Temperature range (°C)		Brazing alloys	Corrosive	Non corrosive	Standard	Powder	Paste
SOBAL-FLUX AG 1	500	800	Polyvalent		✓	FH20	✓	✓
SOBAL-FLUX AG4	550	880	Polyvalent		✓	FH20	✓	✓
SOBAL-FLUX AG 2	650	1000	Steel, cast iron		✓	FH20	✓	✓

Copper Phosphorus Alloys:

Product	Melting Range		Alloy Composition			Standard	
	Solidus	Liquidus	Cu	Ph	Other	AWS A5.3	EN ISO 17672
SOPHOS 6	710	890	Bal.	6,3	-	-	CuP 179
SOPHOS 7	710	805	Bal.	7,0	-	BCuP-2	CuP 180
SOPHOS 8	710	750	Bal.	7,8	-	-	CuP 182
SOPHOS Sn	650	700	Bal.	6,7	6,5(Sn)	BCuP-9	CuP 385

Copper Phosphorus Silver Alloys:

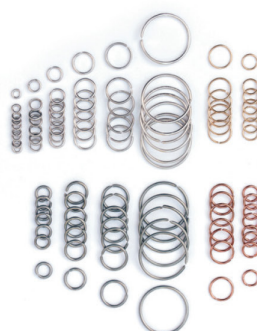
Product	Melting Range		Alloy Composition			Standard	
	Solidus	Liquidus	Ag	Ph	Cu	AWS A5.3	EN ISO 17672
SOPHOS AG2	645	790	2	7,0	-	BCuP-2	CuP 280
SOPHOS AG5	645	810	5	6,0	-	BCuP-3	CuP 281
SOPHOS AG15	645	800	15	5,0	-	BCuP-5	CuP 284
SOPHOS AG18	645	645	18	7,0	-	-	CuP 286

SOLID AND
CORED WIRES

RODS

RINGS

SPECIFIC
SHAPES



SOBRACORE
TECHNOLOGIES FOR BRAZING

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